

Work Order ID **92119 - 2**

Tuesday, October 23, 2012 4:09:53 PM

Split

92119

Page 1

Item ID: PB67-43001-13

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Adjustable Blade Support Assembly

Start Date: 10/23/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/2/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12-10-25 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

B67-43001-13	Rev C
--------------	-------

100		0.00
-----	--	------

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1- make a 0.090" chamfer in the 1.00" hole before welding
2- assemble parts and weld as per dwg
3- grind weld flush in area of PB67-43001-249 only
4- install helicol insert as per dwg

(4x)

CC 12-12-4

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00
-----	--	------

110

QC

Memo

0.00

Quality Control

4

0

05 12-12-04

DAS 18

120	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------

120

QC

Memo

0.00

Quality Control

DAS 15 9-09

12 12 05

4

Work Order ID 92119

Tuesday, October 23, 2012 4:09:53 PM

92119

Page 2

Item ID: PB67-43001-13 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Adjustable Blade Support Assembly
Start Date: 10/23/2012 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 11/2/2012 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00				4	76	12-12-5	
Hand Finishing									
160	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							
160									
Powdercoat	Memo	0.00							
Powder Coating	1- MASK TUBE FROM BASE TO GUSSET								
	START TIME: 2:45								
	OVEN TEMPERATURE: 3200F								
	FINISH TIME: 3:15								
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									

W18144

4X ~~✓~~ MF 12/12/10

4 ~~✓~~ 12/12/10 (259)

Tuesday, October 23, 2012 4:09:53 PM

92119

Page 3

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Aft Adjustable Blade Support Assembly

Start Date: 10/23/2012 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 11/2/2012 **Req'd Qty:** 4.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

180

0.00

180

Small Fab

0.00

Small Fab

Memo

Small Fab

1- match drill cover to existing holes in support
2- assemble as per dwg

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

Quality Control

200

Identify as per dwg & Stock Location: W4

0.00

200

Packaging

Memo

Packaging

Work Order ID 92119

Tuesday, October 23, 2012 4:09:53 PM

92119

Page 4

Item ID: PB67-43001-13

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Aft Adjustable Blade Support Assembly

Stop ***NS2***

Start Date: 10/23/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/2/2012 Req'd Qty: 4.00

4

Customer:

Reference:

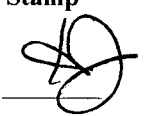
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

13/1/10 
MRF

13-01-09

Picklist Print

Tuesday, October 23, 2012 4:09:53 PM

Page 1

Work Order ID: 92119

Parent Item: PB67-43001-13

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
EC verified by:DD

IPP RevC 10.09.27 per RevC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-67 PB67-43001-67		Manufactured	No			<u>B93495 = 4</u>	Each	1.0000		4		<u>11.12.04</u>	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		1							
				85187		1							
PB67-43001-249 Inner Tube Bushing		Manufactured	No			100	Each	3.0000	1	4		<u>11.12.04</u>	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST438		3							
				52480		3							
PB67-43001-253 Gusset		Manufactured	No			100	Each	7.0000	1	4		<u>11.12.04</u>	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		7							
				85185		7							
PB67-43001-254 Gusset		Manufactured	No			100	Each	16.0000	1	4		<u>11.12.04</u>	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST438		16							
				52481		16							
PB67-43001-255 Inner Tube		Manufactured	No			<u>B90929 = 4</u>	Each	0.0000	1	4		<u>11.12.04</u>	
MS124780 HELICAL INSERT		Purchased	No			180	Each	82.0000	1	4		<u>11.12.04</u>	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST333		82							
				111064		82							

Picklist Print

Tuesday, October 23, 2012 4:09:53 PM

Page 2

Work Order ID: 92119

Parent Item: PB67-43001-13

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 4.00

Required Qty: 4.00

MS27039-1-10

Purchased

No

180

Each

416.0000

8

32

DAS

19 13-01-08

Screw

Location

Loc Qty

Loc Code

308

123522

8

122441

8

GA

100

120449

100

ST291

5

120120

5

ST305

300

122815

300

ST308

3

122027

3

NAS1149D0316J

Purchased

No

180

Each

400.0000

8

32

DAS

19 13-01-08

Washer

Location

Loc Qty

Loc Code

ST298

400

122151

400

NAS1149D0363J

Purchased

No

180

Each

4,785.0000

8

32

DAS

19 13-01-08

Washer

Location

Loc Qty

Loc Code

ST294

1854

123248

1254

123355

600

ST297

2820

122378

2820

ST298

111

117601

61

119537

33

120308

17

Tuesday, October 23, 2012 4:09:53 PM

Shop Packet Print

Page 2

Picklist Print

Tuesday, October 23, 2012 4:09:53 PM

Page 3

Work Order ID: 92119

Parent Item: PB67-43001-13

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 4.00

Required Qty: 4.00

PB67-43001-69
90 Degree Cover Plate

Manufactured No

180

Each

1.0000

1

4

DAS
12/13/13.01.08

Location

Loc Qty

Loc Code

ST437A

B92087 = (3)

1

52433

1

3

PB67-43001-83

Manufactured No

180

Each

5.0000

1

4

DAS
12/13.01.08

PB67-43001-83

Location

Loc Qty

Loc Code

ST444

B90819 = (3)

5

53240

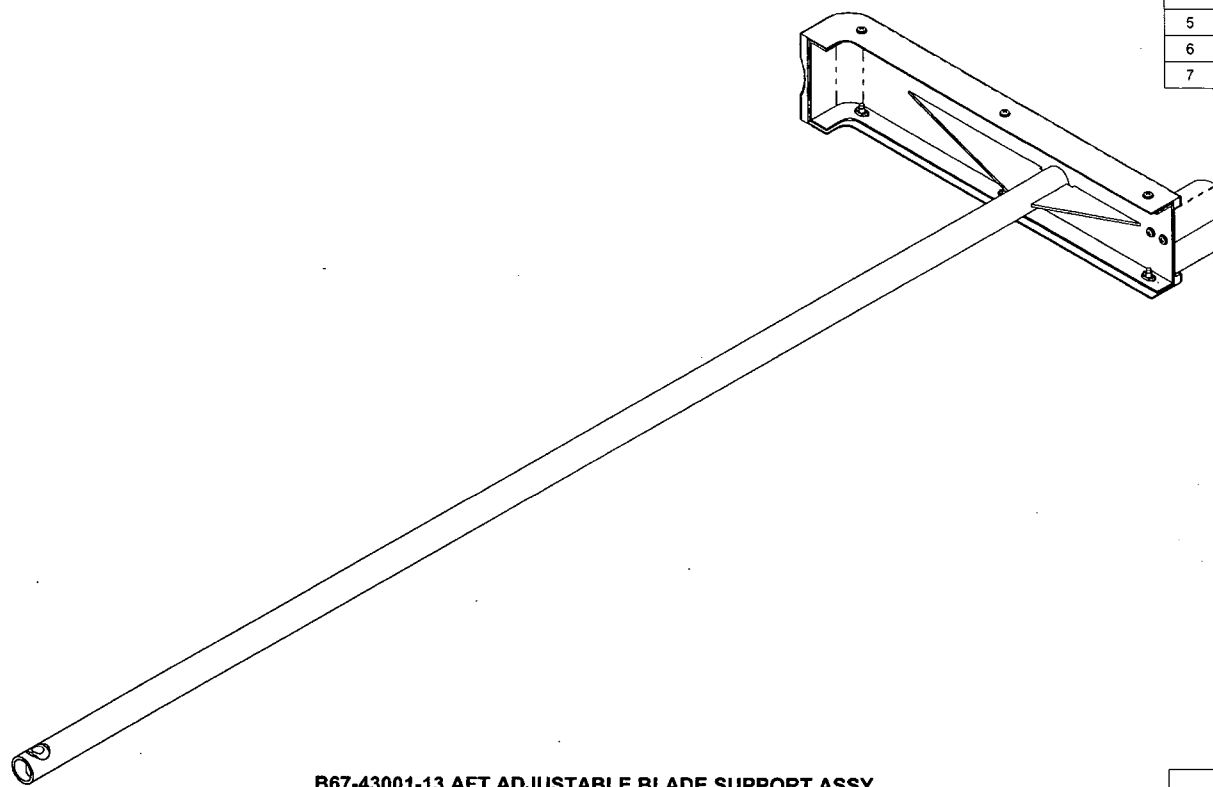
5

3

Tuesday, October 23, 2012 4:09:53 PM

Shop Packet Print

Page 3



B67-43001-13 AFT ADJUSTABLE BLADE SUPPORT ASSY

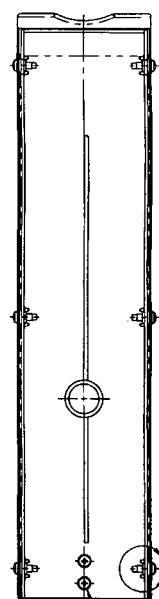
ITEM	QTY -13	P/N	DESCRIPTION
1	X	B67-43001-13	AFT ADJUSTABLE BLADE SUPPORT ASSEMBLY
2	1	B67-43001-13W	AFT ADJUSTABLE BLADE SUPPORT WELDMENT
3	1	B67-43001-69	90° COVER PLATE ASSEMBLY
4	1	B67-43001-83	SHORT D-PAD ASSY
5	8	MS27039-1-10	SCREW
6	8	NAS1149D0316J	WASHER
7	6	NAS1149D0363J	WASHER

COPY
 RETURN TO
 ORDERING
 EXCLUDED COPY
 NO AMENDMENT
 NOTICE
 ORDER

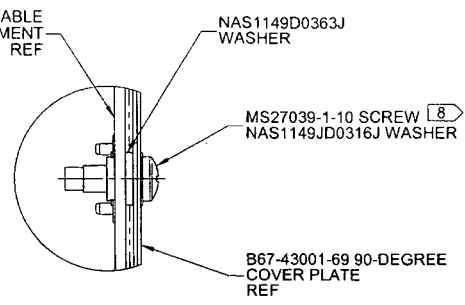
92119-MCS
 12-10-25

RELEASED
 2010-09-16
 MP

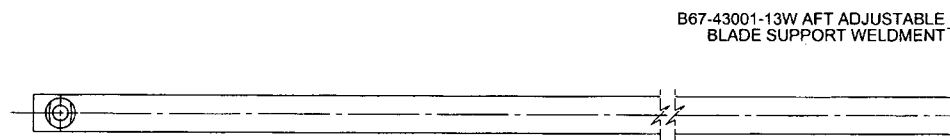
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 8 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.28
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED		DRAWING NO.	REV. C	
MFG. APPR.		B67-43001-13	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.	N/A	AFT ADJUSTABLE BLADE SUPPORT ASSY	NTS	
DATE	10.04.28		COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



MS27039-1-10 SCREW
NAS1149JD0316J WASHER
2 PL [8]



SECTION A-A B7-2
SCALE 4X, 6 PL



B67-43001-69
90° COVER PLATE ASSEMBLY

B67-43001-83
D-PAD ASSEMBLY, SHORT

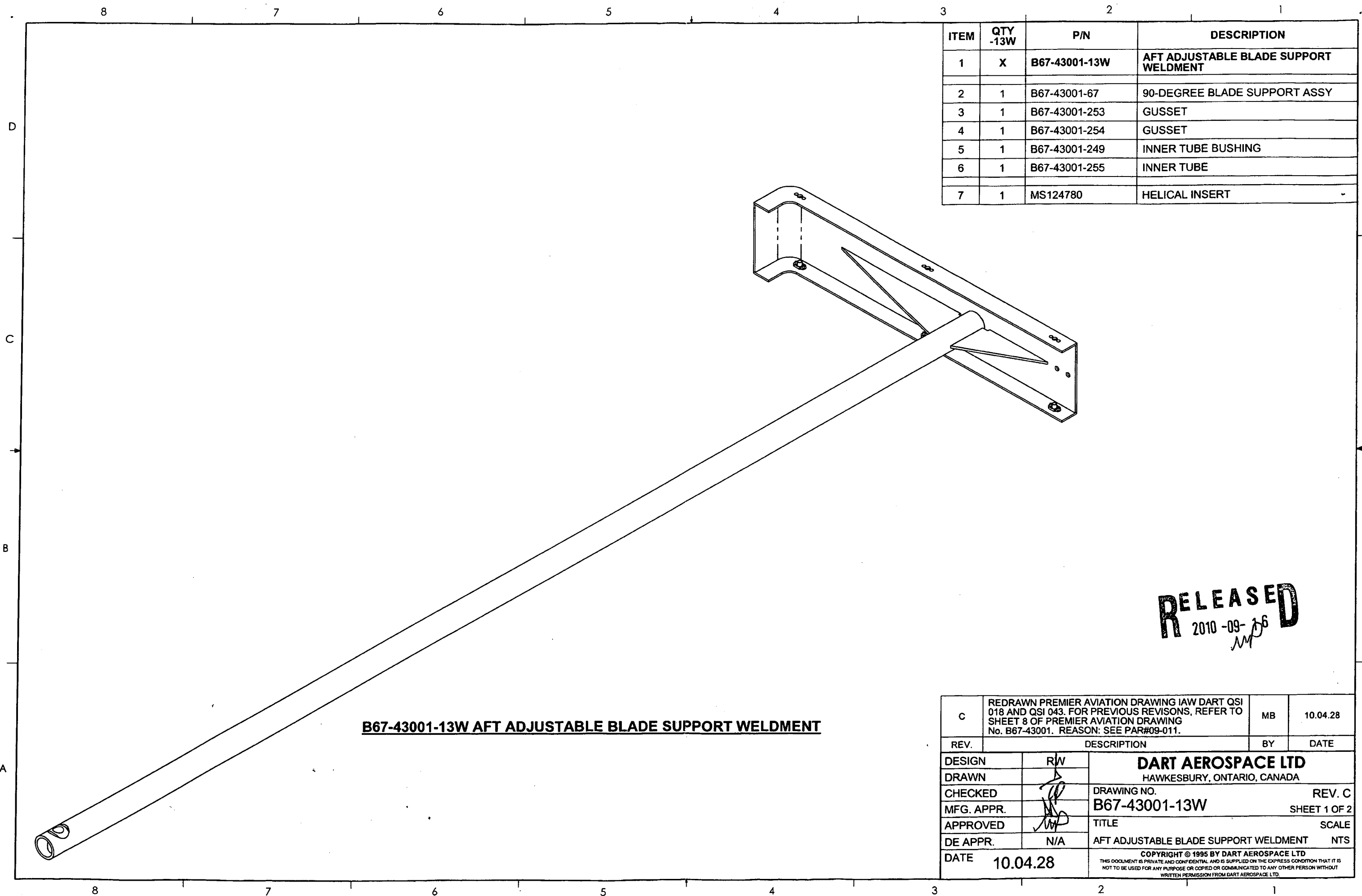
B67-43001-13 AFT ADJUSTABLE BLADE SUPPORT ASSY

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.21 lbs
- 8) LOCATE PARTS AS SHOWN AND TRANSFER DRILL $\phi 0.250$ TO $\phi 0.257$ HOLES FROM EXISTING HOLE PATTERNS ON B67-43001-13W AND B67-43001-83 TO B67-43001-69

RELEASED
2010-09-16

DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-13	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	AFT ADJUSTABLE BLADE SUPPORT ASSY	NTS
DATE	10.04.28	<small>COPYRIGHT © 1999 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

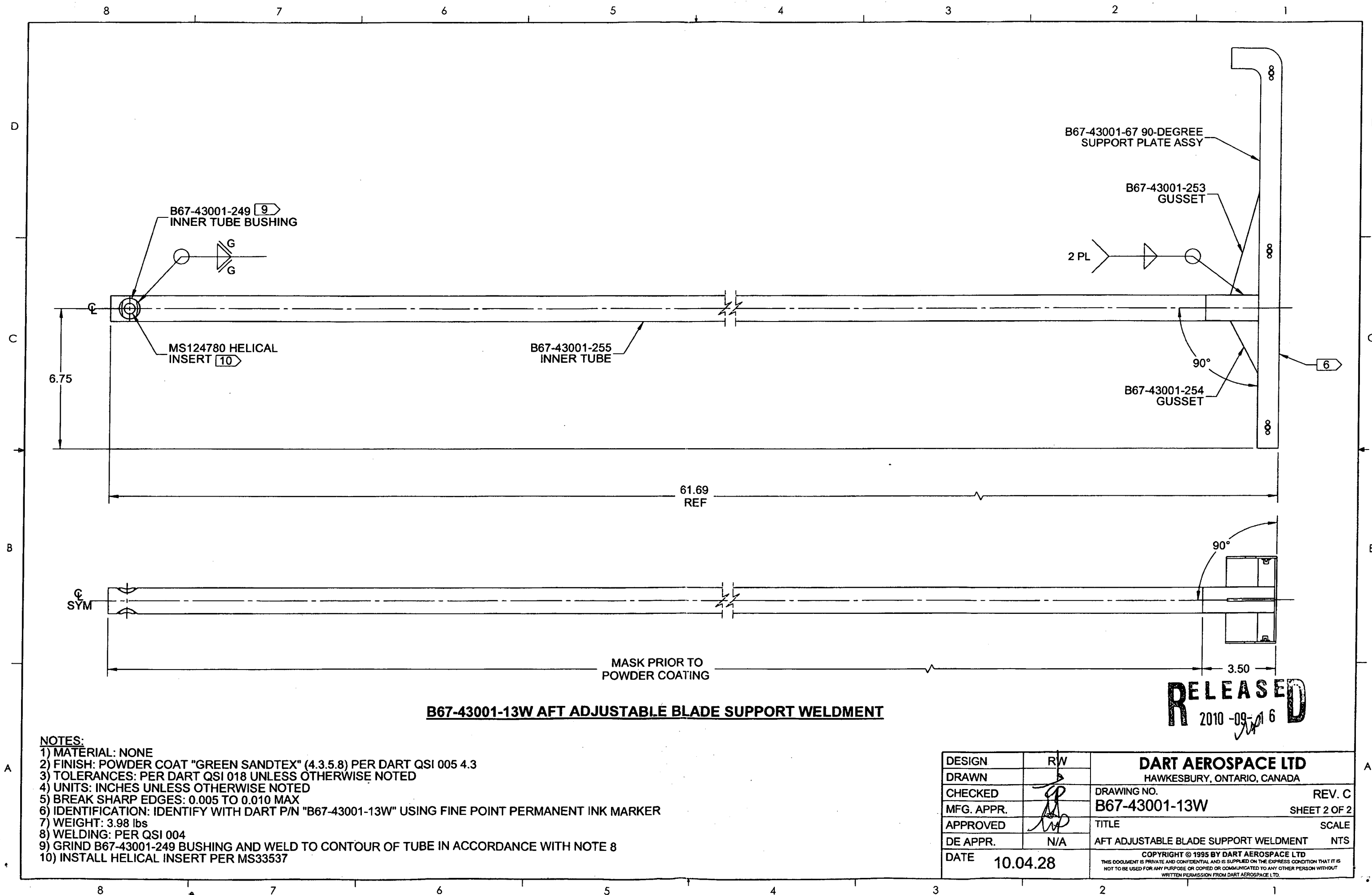


B67-43001-13W AFT ADJUSTABLE BLADE SUPPORT WELDMENT

ITEM	QTY -13W	P/N	DESCRIPTION
1	X	B67-43001-13W	AFT ADJUSTABLE BLADE SUPPORT WELDMENT
2	1	B67-43001-67	90-DEGREE BLADE SUPPORT ASSY
3	1	B67-43001-253	GUSSET
4	1	B67-43001-254	GUSSET
5	1	B67-43001-249	INNER TUBE BUSHING
6	1	B67-43001-255	INNER TUBE
7	1	MS124780	HELICAL INSERT

RELEASED
2010-09-16
MD

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 8 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.28
REV.	DESCRIPTION		BY	DATE
DESIGN	R/W	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	<i>[Signature]</i>			
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C	
MFG. APPR.	<i>[Signature]</i>	B67-43001-13W	SHEET 1 OF 2	
APPROVED	<i>[Signature]</i>	TITLE	SCALE	
DE APPR.	N/A	AFT ADJUSTABLE BLADE SUPPORT WELDMENT	NTS	
DATE	10.04.28	COPYRIGHT © 1995 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		



NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-13W" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 3.98 lbs
- 8) WELDING: PER QSI 004
- 9) GRIND B67-43001-249 BUSHING AND WELD TO CONTOUR OF TUBE IN ACCORDANCE WITH NOTE 8
- 10) INSTALL HELICAL INSERT PER MS33537

DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. B67-43001-13W	REV. C
MFG. APPR.		SHEET 2 OF 2	
APPROVED		TITLE	SCALE
DE APPR.	N/A	AFT ADJUSTABLE BLADE SUPPORT WELDMENT	NTS
DATE	10.04.28	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

